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<b>(21) International Application Number:</b> PCT/NO94/00102 <b>(22) International Filing Date:</b> 1 June 1994 (01.06.94) <b>(30) Priority Data:</b> 932173 14 June 1993 (14.06.93) NO <b>(71) Applicant (for all designated States except US):</b> DEN NORSKE STATS OLJESELSKAP A.S. [NO/NO]; Forus, Postboks 300, N-4001 Stavanger (NO). <b>(72) Inventors; and</b> <b>(75) Inventors/Applicants (for US only):</b> AKPORIAYE, Duncan [GB/NO]; Kristine Bonnevie vei 15, N-0592 Oslo (NO). RØNNEKLEIV, Morten [NO/NO]; Tingveien 23 D, N- 7046 Trondheim (NO). HASSELGARD, Preben [NO/NO]; Sildråpeveien 62 B, N-7048 Trondheim (NO). <b>(74) Agent:</b> TANDBERGS PATENTKONTOR A/S; Boks 7085 H, N-0306 Oslo (NO).		<b>(81) Designated States:</b> AT, AU, BB, BG, BR, BY, CA, CH, CN, CZ, DE, DK, ES, FI, GB, HU, JP, KP, KR, KZ, LK, LU, LV, MG, MN, MW, NL, NO, NZ, PL, PT, RO, RU, SD, SE, SK, UA, US, UZ, VN, European patent (AT, BE, CH, DE, DK, ES, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG).  <b>Published</b> <i>With international search report.</i> <i>In English translation (filed in Norwegian).</i>
<b>(54) Title:</b> NEW CATALYST, AND PROCESSES FOR DEHYDROGENATING DEHYDROGENATABLE HYDROCARBONS <b>(57) Abstract</b> <p>A new catalyst, especially for the dehydrogenation of dehydrogenatable C<sub>2-30</sub> hydrocarbons. The catalyst comprises a carrier consisting essentially of a mixed oxide of magnesium and alumina Mg(Al)<sub>2</sub>O<sub>3</sub>, and also comprises a Group VIII noble metal, a Group IVA metal and optionally a Group IA alkali metal. The catalyst may be subjected to a pretreatment comprising a reduction, a subsequent oxidation and finally a second reduction. The catalyst is particularly suitable for the dehydrogenation of C<sub>2-5</sub> paraffins to olefins, with and without simultaneous oxidation of hydrogen.</p>		

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NEW CATALYST, AND PROCESSES FOR DEHYDROGENATING  
DEHYDROGENATABLE HYDROCARBONS

5           The present invention relates to a new catalyst, a process for preparing the catalyst and processes for the dehydrogenation of dehydrogenatable  $C_{2-30}$  hydrocarbons, preferably  $C_{2-5}$  paraffins, using the new catalyst.

10           The dehydrogenation of paraffins to olefins is of considerable commercial importance due to the need for olefins for the manufacture of products such as high octane gasolines, synthetic elastomers, detergents, plastics, ion exchange resins and pharmaceutical products. For a dehydrogenation process to be commercially useful, it must utilize catalysts  
15 exhibiting a high activity, a high rate of conversion, a high selectivity for the formation of olefins, and a high stability.

          A large number of catalysts are previously known for the dehydrogenation of paraffins. These catalysts comprise a  
20 solid carrier material on an inorganic oxide basis and various catalytic metals and promoter metals deposited on the carrier material or incorporated into the carrier material by other means. Carrier materials on an alumina basis have been widely used in such dehydrogenation catalysts.

25           U.S. Pat. No. 4,788,371 discloses such catalyst and a process for the steam dehydrogenation of dehydrogenatable hydrocarbons with oxidative reheating. A dehydrogenatable  $C_{2-30}$  hydrocarbon, steam and an oxygen-containing gas are contacted in a reaction zone with a catalyst comprising a Group VIII  
30 noble metal, one or more components selected from lithium, potassium, rubidium, cesium and francium, and a component selected from boron, gallium, indium, germanium, tin and lead, deposited on an inorganic oxide carrier material. The preferred carrier material is alumina having a surface area of 1-  
35 500  $m^2/g$ , preferably 5-120  $m^2/g$ . Alumina is employed as the catalyst carrier in all the working examples of the patent. A preferred catalyst according to said U.S. patent contains about 0.70 wt.% of platinum, about 0.50 wt.% of tin and about 3.86 wt.% of cesium, and has a surface area of about 85  $m^2/g$ .

Mixtures of magnesium oxide MgO and alumina  $\text{Al}_2\text{O}_3$  and mixed oxides of Mg and Al have also been utilized as catalysts, and as carrier materials for catalysts. International Patent Application No. PCT/JP89/00053 discloses an alkoxylation catalyst comprising a magnesium oxide that has been modified by adding thereto at least one trivalent metal ion, preferably selected from  $\text{Al}^{3+}$  and  $\text{Ga}^{3+}$ . British Patent Application GB 2,225,731 discloses a catalyst for hydrotreatment, e.g. hydrodemetallization or hydrodesulphurization, comprising in a substantially homogenous phase magnesia and alumina wherein the molar ratio of Mg to Al is preferably from 3:1 to 10:1, together with a Group VI metal and/or at least one Group VIII metal.

It has now been found that if a mixed oxide of Mg and Al is used in combination with a Group VIII noble metal and certain promoters of the kind disclosed in the above-mentioned U.S. Pat. No. 4,788,371, a catalyst can be obtained which exhibits improved activity and stability when used for dehydrogenating dehydrogenatable hydrocarbons.

Thus, the invention provides a catalyst comprising a combination of a carrier, constituted essentially by a mixed oxide of magnesium and aluminum  $\text{Mg}(\text{Al})\text{O}$ , a Group VIII noble metal, a Group IVA metal, and optionally a Group IA alkali metal.

Preferably, the catalyst has been subjected to a pretreatment comprising a reduction, preferably in hydrogen, a subsequent oxidation, preferably in air optionally mixed with nitrogen, and finally a second reduction, preferably in hydrogen (ROR pretreatment; ROR = Reduction-Oxidation-Reduction).

The Group VIII noble metal is preferably selected from platinum and palladium, with platinum being the most preferred. The Group IVA metal is preferably selected from tin and germanium, with the most preferred metal being tin.

It has further been shown that the selectivity of the new catalysts in a dehydrogenation process is further improved by including therein a Group IA alkali metal, preferably cesium or potassium, most preferably cesium.

It is remarkable that the new catalyst exhibits a

very high activity in the dehydrogenation of hydrocarbons even with a low content of Group VIII noble metal of e.g. 0.2-0.4 wt.%.

The Group VIII metal, the Group IVA metal and the optional Group IA metal can be incorporated into the carrier by any of the methods known in the art. A preferred method consists in impregnating the oxide carrier with solutions or suspensions of decomposable compounds of the metals to be incorporated.

The catalyst and its preparation is described in more detail below with reference to embodiments wherein platinum, tin and optionally cesium are deposited on the carrier material, but the description is also valid for the deposition of other metals within the scope of the invention, with any adaptations that will be obvious to a person skilled in the art.

The mixed oxide of magnesium and aluminum,  $Mg(Al)O$ , which is utilized as a carrier material in the catalyst of the invention, can be prepared by adding a solution of sodium hydroxide and sodium carbonate to a solution of magnesium nitrate and aluminum nitrate according to the method described in Journal of Catalysis 94 (1985), pp. 547-557. Instead of sodium hydroxide and sodium carbonate, potassium hydroxide and potassium carbonate can be used, see Applied Catalysis 54 (1989) pp. 79-90. By evaporation (drying) of the above mentioned mixtures the compound hydrotalcite,  $Mg_6Al_2(OH)_{16}CO_3 \cdot 4H_2O$ , is formed, which compound is calcined at 500° to 800°C to give  $Mg(Al)O$ . It is preferred, however, to modify this process somewhat by using ammonium hydroxide and ammonium carbonate instead of the respective compounds sodium hydroxide/potassium hydroxide and sodium carbonate/potassium carbonate, whereby a larger and more stable surface area is obtained. The obtained  $Mg(Al)O$  is characterized by a magnesia structure wherein some of the magnesium atoms are replaced by aluminum atoms. The molar ratio of Mg to Al is typically ranging from 1:1 to 10:1, and the surface area is typically ranging from 100 to 300 m<sup>2</sup>/g, preferably from 140 to 210 m<sup>2</sup>/g. The particle size can be in the range of 100 µm to 20 nm.

The deposition of platinum and tin on the  $Mg(Al)O$

carrier material can advantageously be carried out in one step, e.g. by using tin chloride and hexachloroplatinic acid dissolved in ethanol. A method for depositing platinum and tin in a single step is described in J. Catalysis, Vol. 128, 1991, page 1. By carrying out a simultaneous deposition of platinum and tin on the Mg(Al)O material, the number of required calcination steps is reduced, which makes it easier to obtain a high surface area of the Mg(Al)O material. Other suitable impregnation procedures are described in the above-mentioned U.S. Pat. No. 4,788,371, in U.S. Pat. No. 4,962,265 and in EP 0,098,622.

In cases where the catalyst shall contain cesium, a deposition of cesium can be effected in a separate step, after the deposition of tin and platinum and the subsequent calcination, using cesium nitrate dissolved in water. The impregnation with cesium nitrate can be carried out as described in U.S. Pat. No. 4,788,371.

The ROR pretreatment of the catalyst is conveniently effected by carrying out a reduction of the catalyst in hydrogen, a subsequent oxidation in air optionally mixed with nitrogen, and finally a second reduction in hydrogen. The pretreatment can be carried out at temperatures in the range of 500° to 700°C and by using space velocities (GHSV) for the treatment gases of 10 to 100,000 N ml g<sup>-1</sup> h<sup>-1</sup>, preferably 100 to 5000 N ml g<sup>-1</sup> h<sup>-1</sup>. The initial reduction of the catalyst with hydrogen is carried out for a period of 1 minute to 10 hours, usually for about 2 hours. The subsequent oxidation of the reduced catalyst in air optionally mixed with nitrogen is carried out for a period of 1 minute to 10 hours, usually for about 2 hours. The oxidation may advantageously be accomplished by first treating the catalyst for about 1 hour in a stream of nitrogen containing about 20% by volume of air, and then treating it for about 1 hour in pure air. The final reduction with hydrogen is carried out under similar conditions as the initial reduction.

Thus, the invention also relates to a process for preparing the above-described ROR pretreated catalyst. The process is characterized by the steps of incorporating a Group VIII noble metal, a Group IVA metal and optionally a Group IA

alkali metal into a carrier consisting essentially of a mixed oxide of magnesium and aluminum  $Mg(Al)O$ , and subjecting the material thus obtained to a pretreatment (ROR pretreatment) comprising a reduction, preferably in hydrogen, a subsequent  
5 oxidation, preferably in air optionally mixed with nitrogen, and finally a second reduction, preferably in hydrogen.

The invention further provides a process for dehydrogenating dehydrogenatable  $C_{2-30}$  hydrocarbons, preferably  $C_{2-5}$  paraffins, comprising contacting the hydrocarbons, under  
10 suitable dehydrogenation conditions in one or more reaction zones, with a solid catalyst comprising a combination of a carrier, constituted essentially by a mixed oxide of magnesium and aluminum  $Mg(Al)O$ , a Group VIII noble metal, a Group IVA metal and optionally a Group IA alkali metal.

15 In accordance with usual practice in the dehydrogenation of hydrocarbons, the hydrocarbons are preferably contacted with the solid catalyst in a gaseous phase, mixed with usual additives such as steam, nitrogen and hydrogen. The feed mixture containing the hydrocarbons is  
20 preferably introduced into a reactor having one or more fixed catalyst beds, and the dehydrogenation is preferably carried out at a temperature ranging from  $500^{\circ}$  to  $700^{\circ}C$ , at a pressure ranging from 0.5 to 1.5 bars absolute, and using a space velocity (GHSV) ranging from 10 to 10.000  $N\ ml\ g^{-1}\ h^{-1}$ .

25 The new catalyst has also been shown to be very suitable in cases where the dehydrogenation of hydrocarbons is carried out in combination with admixing of oxygen and combustion of hydrogen, because the new catalyst also exhibits a selective catalytic effect on the oxidation of hydrogen to  
30 water.

It is well known in the art of dehydrogenating dehydrogenatable hydrocarbons that it is advantageous to oxidize with an oxygen-containing gas the hydrogen formed in the reaction. Because the dehydrogenation process is endothermic,  
35 oxidation of the formed hydrogen can be utilized to maintain the desired reaction temperature during the dehydrogenation. For such heating purpose it will often be advantageous even to add a supplementary amount of recirculated hydrogen to the reaction mixture. In addition to achieving a desired heat

balance, the lowering of the hydrogen concentration in the reaction mixture resulting from the combustion will shift the equilibrium of the desired dehydrogenation reactions in the direction of higher yields of unsaturated hydrocarbons.

5 Although it will be advantageous for that reason to achieve a high hydrogen conversion, it is important however to avoid excessive concurrent oxidation of hydrocarbons, which would reduce the total yield of the process. It is therefore important to achieve a maximum of selectivity of the oxidation of  
10 the hydrogen formed in the dehydrogenation process. It has been found that such selective oxidation is achieved with the new catalyst.

Thus, the invention also provides a process for dehydrogenating dehydrogenatable  $C_{2-30}$  hydrocarbons, preferably  
15  $C_{2-5}$  paraffins, in combination with admixing of an oxygen-containing gas, preferably oxygen, and combustion of hydrogen, comprising contacting the hydrocarbons under suitable dehydrogenation conditions in one or more reaction zones, with a solid catalyst comprising a combination of a carrier, constituted essentially by a mixed oxide of magnesium and aluminum  
20  $Mg(Al)O$ , a Group VIII noble metal, a Group IVA metal and optionally a Group IA alkali metal.

In accordance with usual practice in such dehydrogenation of hydrocarbons, the hydrocarbons are  
25 contacted with the solid catalyst in a gaseous phase, mixed with an oxygen-containing gas and with usual additives such as steam, any supplementary quantities of hydrogen, and nitrogen. The feed mixture containing the hydrocarbons is preferably introduced into a reactor having one or more fixed catalyst  
30 beds, with oxygen-containing gas being introduced and admixed with the feed stream even between the catalyst beds when more than one such bed is used. The dehydrogenation is preferably carried out at a temperature ranging from  $400^{\circ}$  to  $700^{\circ}C$ , at a pressure ranging from 0.5 to 3 bars absolute, and using a  
35 space velocity (GHSV) ranging from 10 to  $10.000\ N\ ml\ g^{-1}\ h^{-1}$ .

In both of the two types of the dehydrogenation process the activity of the catalyst will decrease with time. When the activity has become undesirably low, the catalyst may be regenerated, e.g. in the same reactor. The regeneration can



be carried out by burning off the coke that has been formed on the catalyst, with an oxygen-containing gas for a period of time ranging from 1 minute to 10 hours, preferably in a stream of air optionally mixed with nitrogen. The catalyst is then  
5 subjected to a reduction treatment for a period of 1 minute to 10 hours in a stream of hydrogen. Said treatments are suitably carried out at 300° to 700°C using a space velocity (GHSV) for the treatment streams of 10 to 10,000 N ml g<sup>-1</sup> h<sup>-1</sup>, preferably 100 to 5000 N ml g<sup>-1</sup> h<sup>-1</sup>. If desired, a redispersion of the  
10 noble metal, e.g. platinum, in the catalyst can be effected using a chlorine-containing gas after the burning off of the coke but prior to the reduction treatment.

The regeneration of the catalyst restores to a substantial extent the original characteristics of the catalyst.  
15 The restoration of the activity and the selectivity of the catalyst will be more complete in the temperature range of 300°C to 400°C than at the higher temperatures. Admixing nitrogen with the air stream utilized for the oxidation also tends to improve the restoration of the properties of the  
20 catalyst.

Compared to the previously known dehydrogenation catalysts on an alumina basis, the new catalyst exhibits improved activity and improved stability.

The following examples illustrate the invention.

25

#### Example 1.

A Mg(Al)O material having an atomic ratio of Mg to Al of 2:1 to 3:1 was prepared according to the following procedure: An aqueous solution of 1.13 moles of NaOH and 0.045  
30 mole of Na<sub>2</sub>CO<sub>3</sub> was treated with a solution of 0.91 mole of Mg(NO<sub>3</sub>)<sub>2</sub>·6H<sub>2</sub>O and 0.09 mole of Al(NO<sub>3</sub>)<sub>3</sub>·9H<sub>2</sub>O at about 75°C (pH = 9.5). After filtration, washing and drying at about 100°C for about 15 hours, a hydrotalcite Mg<sub>6</sub>Al<sub>2</sub>(OH)<sub>16</sub>CO<sub>3</sub>·4H<sub>2</sub>O was formed. The structure was confirmed by X-ray diffraction analysis. The  
35 material thus obtained was calcined at 700°C for about 15 hours, whereby Mg(Al)O was formed. The structure was confirmed by X-ray diffraction analysis, and the surface area was measured to be 156 m<sup>2</sup>/g.

Example 2

A Mg(Al)O material having an atomic ratio of Mg to Al of 2:1 to 3:1 was prepared according to the following procedure: An aqueous solution of 1.13 moles of  $\text{NH}_4\text{OH}$  and 0.045 mole of  $(\text{NH}_4)_2\text{CO}_3$  was treated with a solution of 0.91 mole of  $\text{Mg}(\text{NO}_3)_2 \cdot 6\text{H}_2\text{O}$  and 0.09 mole of  $\text{Al}(\text{NO}_3)_3 \cdot 9\text{H}_2\text{O}$  at a temperature of about  $75^\circ\text{C}$  ( $\text{pH} = 9.5$ ). After filtration, washing and drying at about  $100^\circ\text{C}$  for about 15 hours, a hydrotalcite  $\text{Mg}_6\text{Al}_2(\text{OH})_{16}\text{CO}_3 \cdot 4\text{H}_2\text{O}$  was formed. The material thus obtained was calcined at  $700^\circ\text{C}$  for about 15 hours, whereby Mg(Al)O was formed. The structure was confirmed by X-ray diffraction analysis, and the surface area was measured to be  $198 \text{ m}^2/\text{g}$ .

Example 3

A Mg(Al)O material having a particle size of 300-400  $\mu\text{m}$ , prepared according to Example 1, was impregnated with a solution containing tin chloride and hexachloroplatinic acid and with a solution of cesium nitrate, according to the following procedure: 0.1150 g  $\text{SnCl}_2 \cdot 2\text{H}_2\text{O}$  and 0.0805 g  $\text{H}_2\text{PtCl}_6 \cdot 6\text{H}_2\text{O}$  were dissolved in 60 ml of ethanol and the mixture was added to 10.1 g of Mg(Al)O. After completion of the impregnation the material thus obtained was evaporated to dryness in a vacuum and was then dried at about  $100^\circ\text{C}$  for about 15 hours, whereupon the dried material was calcined at  $560^\circ\text{C}$  for about 3 hours in air supplied in an amount of  $100 \text{ cm}^3/\text{min}$ .

0.0711 g  $\text{CsNO}_3$  dissolved in 25 ml of water was then added to the calcined material. Upon completion of the impregnation, the material thus obtained was dried at about  $100^\circ\text{C}$  for about 15 hours. The dried material was calcined at  $560^\circ\text{C}$  for about 3 hours in air supplied in an amount of  $100 \text{ cm}^3/\text{min}$ .

3 g of the calcined product were then reduced at  $600^\circ\text{C}$  for 2 hours in a stream of  $\text{H}_2$  supplied in an amount of  $20 \text{ cm}^3/\text{min}$ .

The reduced product was then oxidized at  $600^\circ\text{C}$  for about 1 hour in a stream of  $\text{N}_2$  containing 20% by volume of air, added in an amount of  $50 \text{ cm}^3/\text{min}$ , and for about 1 hour in pure air supplied in an amount of  $50 \text{ cm}^3/\text{min}$ . The oxidized product

was then reduced in the same manner as before the oxidation.

A catalyst was obtained which had the following chemical composition:

5                   0.3 wt.% Pt  
                  0.6 wt.% Sn  
                  0.5 wt.% Cs  
                  98.6 wt.% Mg(Al)O.

10               The catalyst was tested for a dehydrogenation of propane in a microreactor equipped with a fixed catalyst bed, at the following conditions:

	Dehydrogenation temperature:	600°C
15	Dehydrogenation pressure:	1 bar abs.
	Space velocity (GHSV):	2100 N ml g <sup>-1</sup> h <sup>-1</sup>
	Amount of catalyst:	3.0 g
	Composition of the feed stream:	
	Propane	35 Nml/min
20	Hydrogen	5 Nml/min
	Nitrogen	25 Nml/min
	Steam	41 Nml/min

The results thereby obtained are given in Table 1.

25

#### Example 4 - Comparison Example.

The procedure of Example 3 was repeated, with the following exception: After the first reduction of the calcined product with H<sub>2</sub>, the oxidation in air-containing N<sub>2</sub> and the  
30 subsequent second reduction with H<sub>2</sub> were omitted.

The catalyst was used for a dehydrogenation of propane under the same conditions as in Example 3. The results obtained are given in Table 1.

#### 35 Example 5

The procedure of Example 3 was followed, including the post-treatment consisting in a reduction, a subsequent oxidation, and a second reduction (ROR pretreatment) of the calcined catalyst, but the impregnation with CsNO<sub>3</sub> for

incorporation of cesium was omitted. The impregnation with a solution containing tin chloride and hexachloroplatinic acid was accomplished in the presence of quantities of tin chloride and hexachloroplatinic acid resulting in a catalyst having the  
5 chemical composition:

0.3 wt.% Pt  
0.6 wt.% Sn  
99.1 wt.% Mg(Al)O.

10

The catalyst was used for a dehydrogenation of propane under the same conditions as in Example 3. The results obtained are given in Table 1.

15 Example 6

A Mg(Al)O material having a particle size of 300-400  $\mu\text{m}$ , prepared according to Example 2, was impregnated with a solution containing tin chloride and hexachloroplatinic acid according to the following procedure:  
20 0.1150 g  $\text{SnCl}_2 \cdot 2\text{H}_2\text{O}$  and 0.0805 g  $\text{H}_2\text{PtCl}_6 \cdot 6\text{H}_2\text{O}$  were dissolved in 60 ml of ethanol and the mixture was added to 10.1 g of Mg(Al)O. After completion of the impregnation the material thus obtained was evaporated to dryness in a vacuum and then dried at about 100°C for about 15 hours, whereupon the dried material  
25 was calcined at 560°C for about 3 hours in air supplied in an amount of 100  $\text{cm}^3/\text{min}$ .

3 g of the calcined product were then reduced at 600°C for 2 hours in a stream of  $\text{H}_2$  supplied in an amount of 20  $\text{cm}^3/\text{min}$ .

30 The reduced product was thereafter oxidized at 600°C for about 1 hour in a stream of  $\text{N}_2$  containing 20% by volume of air, supplied in an amount of 50  $\text{cm}^3/\text{min}$ , and for about 1 hour in pure air supplied in an amount of 50  $\text{cm}^3/\text{min}$ . The oxidized product was then reduced in the same manner as before the  
35 oxidation.

A catalyst was obtained which had the following chemical composition:

0.3 wt.% Pt  
0.6 wt.% Sn  
99.1 wt.% Mg(Al)O.

5           The catalyst was used for a dehydrogenation of propane under the same conditions as in Example 3. The results obtained are given in Table 1.

#### Example 7

10           The procedure of Example 6 was followed, including the post-treatment consisting in a reduction, a subsequent oxidation, and a second reduction (ROR pretreatment) of the calcined catalyst, but the impregnation with a solution containing tin chloride and hexachloroplatinic acid was  
15 accomplished in the presence of quantities of tin chloride and hexachloroplatinum acid resulting in a catalyst having the chemical composition:

0.3 wt.% Pt  
20           0.9 wt.% Sn  
98.8 wt.% Mg(Al)O.

          The catalyst was used in dehydrogenation of propane under the same conditions as in Example 3. The results  
25 obtained are given in Table 1.

#### Example 8

          The procedure of Example 6 was followed, including the post-treatment consisting in a reduction, a subsequent  
30 oxidation, and a second reduction (ROR pretreatment) of the calcined catalyst, but the impregnation with a solution containing tin chloride and hexachloroplatinic acid was accomplished in the presence of such quantities of tin chloride and hexachloroplatinum acid that a catalyst was  
35 obtained having the chemical composition:

0.3 wt.% Pt  
1.2 wt.% Sn  
98.5 wt.% Mg(Al)O.

The catalyst was used for a dehydrogenation of propane under the same conditions as in Example 3. The results obtained are given in Table 1.

5 Example 9 - Comparison Example.

A known dehydrogenation catalyst was prepared according to the process disclosed in U.S. Pat. No. 4,788,371. 0.179 g of  $\text{SnCl}_2 \cdot 2\text{H}_2\text{O}$  dissolved in 14 ml of water was added to 18.8 g of  $\theta$ -alumina having a particle size of 100 to 400  $\mu\text{m}$ .  
10 After completion of the impregnation, the resulting material was dried at about  $100^\circ\text{C}$  for about 6 hours. The dried material was calcined for about 3 hours at  $600^\circ\text{C}$  in a stream of air supplied in an amount of  $100\text{ cm}^3/\text{min}$ .

0.349 g of  $\text{H}_2\text{PtCl}_6 \cdot 6\text{H}_2\text{O}$  dissolved in 14 ml of water was  
15 added to the calcined material. After completion of the impregnation, the resulting material was dried at about  $100^\circ\text{C}$  for about 15 hours. The dried material was calcined for a period of 3 hours at  $570^\circ\text{C}$  in a stream of air containing 10% of steam and supplied in an amount of about  $100\text{ cm}^3/\text{min}$ .

20 1.06 g of  $\text{CsNO}_3$  dissolved in 14 ml of water were added to the calcined material. Upon completion of the impregnation, the resulting material was dried at about  $100^\circ\text{C}$  for about 30 hours. The dried material was calcined for about 3 hours at  $570^\circ\text{C}$  in an air stream supplied in an amount of  
25 about  $100\text{ cm}^3/\text{min}$ .

3 g of the obtained catalyst were then reduced at  $600^\circ\text{C}$  for about 2 hours in a stream of  $\text{H}_2$  supplied in an amount of  $20\text{ cm}^3/\text{min}$ .

A catalyst was obtained having the chemical  
30 composition:

0.7 wt.% Pt  
0.5 wt.% Sn  
3.9 wt.% Cs  
94.9 wt.%  $\theta$ -alumina.

35

The catalyst was used for a dehydrogenation of propane under the same conditions as in Example 3. The results obtained are given in Table 1.

Example 10 - Comparison Example.

A catalyst was prepared according to Example 9, whereupon 3 g of the reduced catalyst were oxidized at 600°C for about 1 hour in a stream of N<sub>2</sub> containing 20% by volume of air, supplied in an amount of 50 cm<sup>3</sup>/min, and for about 1 hour in pure air supplied in an amount of 50 cm<sup>3</sup>/min. The oxidized product was then reduced in the same manner as before the oxidation, i.e. at 600°C for a period of 2 hours in a stream of H<sub>2</sub> supplied in an amount of 20 cm<sup>3</sup>/min.

Thus, the post-treatment of the catalyst accomplished after the calcination corresponded to a ROR pretreatment as prescribed for the catalysts of the invention.

The catalyst was used for a dehydrogenation of propane under the same conditions as in Example 3. The results obtained are given in Table 1.

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TABLE 1 Dehydrogenation of propane to propene.

Example	Carrier	Metal content (wt.%)	Conv. of propane 5 h (%)	Conv. of propane 25 h (%)	C-sel. to propene 5h (%)	C-sel. to propene 25 h (%)	Yield of propene <sup>5</sup> 25 h (%)
3	Mg(Al)O	0.3 Pt 0.6 Sn 0.5 Cs	52.8	45.6	97.5	97.8	44.6
4 <sup>1</sup>	"	0.3 Pt 0.6 Sn 0.5 Cs	19.3	16.7	97.8	97.3	16.2
Comp. cat.							
5	"	0.3 Pt 0.6 Sn	58.7	53.0	93.3	97.3	51.6
6 <sup>2</sup>	"	0.3 Pt 0.6 Sn	58.8	57.5	93.0	95.9	55.1
7 <sup>2</sup>	"	0.3 Pt 0.9 Sn	58.0	57.8	93.9	96.1	55.5
8 <sup>2</sup>	"	0.3 Pt 1.2 Sn	58.6	57.5	94.9	95.9	55.1
9 <sup>3</sup>	$\theta$ -Al <sub>2</sub> O <sub>3</sub>	0.7 Pt 0.5 Sn 3.9 Cs	38.0	27.0	97.0	95.0	25.7
Comp. cat.							
10 <sup>4</sup>	$\theta$ -Al <sub>2</sub> O <sub>3</sub>	0.7 Pt 0.5 Sn 3.9 Cs	41.4	31.0	96.4	95.9	29.7
Comp. cat.							

<sup>1</sup> Without ROR pretreatment.<sup>2</sup> Mg(Al)O having a large surface area (198 m<sup>2</sup>/g).<sup>3</sup> A catalyst known from U.S. Pat. 4,788,371.<sup>4</sup> A catalyst known from U.S. Pat. 4,788,371 but subjected to a ROR pretreatment.<sup>5</sup> Yield of propene =  $\frac{\text{Number of moles of C as C}_3\text{H}_6}{\text{Number of moles of C as C}_3\text{H}_8 + \text{Number of moles of C in products}}$



The results in Table 1 show that a ROR pretreated catalyst of the invention provides a large increase in the propane conversion compared to a similar catalyst not having been subjected to such pretreatment (Example 3 compared to  
5 Example 4). The selectivity for forming propene is retained at about the same level, whereby the total yield of propene is substantially increased.

The results in Table 1 also show that an increase in the surface area of the Mg(Al)O material from 156 m<sup>2</sup>/g to 198  
10 m<sup>2</sup>/g results in a somewhat more stable catalyst and consequently in an increased yield of propene after 25 hours (Example 6 compared to Example 5).

An increase of the catalysts' content of Sn from 0.6 wt.% to 0.9 wt.% appears to result in a further increased  
15 yield of propene (Example 7 compared to Example 6).

The previously known catalyst of Example 9 gives a substantially lower yield of propene than the new catalysts (Examples 3, 5, 6, 7, 8). When the previously known catalyst of Example 9 is subjected to a complete ROR pretreatment as  
20 prescribed according to the invention (Example 10), the yield is improved even for said previously known catalyst. Nonetheless, the improving effect of the ROR pretreatment is not nearly as good for the known catalyst as for the new catalysts. Thus, the new catalysts also give a substantially  
25 better yield of propene than the ROR pretreated catalyst of Example 10.

#### Example 11

The performance of one of the new catalysts of the  
30 invention was compared to the performance of a previously known catalyst for a dehydrogenation of propane accomplished in combination with combustion of hydrogen with an oxygen-containing gas. The combination of dehydrogenation and hydrogen combustion was carried out in a reactor comprising  
35 two catalyst zones and an intermediary oxygen admixing zone. In addition to oxygen being added to the feed to the first catalyst zone, oxygen was also introduced into said oxygen admixing zone between said two catalyst zones.

The new catalyst (I) consisted of 0.3 wt.% Pt and 1.2

wt.% Sn on Mg(Al)O and was a catalyst similar to the one of Example 8 above, except that it had been prepared with a particle size of 1-2 mm.

The known catalyst (II) was a catalyst according to U.S. Pat. No. 4,788,371, consisting of 0.65 wt.% Pt, 1.15 wt.% Sn and 2.18 wt.% Cs on  $\theta$ -alumina. Catalyst (II) had been prepared according to said U.S. Pat. No. 4,788,371, as described in Example 9 above, except that similarly with the new catalyst (I) it had been prepared with a particle size of 1-2 mm.

The conditions employed in the combined dehydrogenation and hydrogen combustion, and the results obtained, are summarized in the following Table 2.

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TABLE 2

Dehydrogenation of propane to propene,  
with combustion of hydrogen.

		Cat. II <sup>(1)</sup>	Cat. I <sup>(2)</sup>
<u>Amount of catalyst</u>			
10	Total (g)	119.3	77.6
	Step 1 (g)	29.8	19.1
	Step 2 (g)	89.5	58.5
<u>Main stream</u>			
15	C <sub>3</sub> H <sub>8</sub> (N ml/min)	1000	1000
	H <sub>2</sub> (N ml/min)	400	400
	N <sub>2</sub> (N ml/min)	45	45
	O <sub>2</sub> (N ml/min)	130	130
	H <sub>2</sub> O (N ml/min)	1040	1040
<u>Admixed stream</u>			
20	O <sub>2</sub> (N ml/min)	130	130
	N <sub>2</sub> (N ml/min)	45	45
<u>Other conditions</u>			
25	Dehydrogen. temp. (°C)	600	600
	(GHSV) (N ml g <sup>-1</sup> h <sup>-1</sup> )	1400	2100
<u>Results</u>			
30	Conv. of C <sub>3</sub> H <sub>8</sub> (5h) (%)	45	57
	C-sel. to C <sub>3</sub> H <sub>6</sub> (5h) (%)	94	90
	Conv. of C <sub>3</sub> H <sub>8</sub> (20h) (%)	30	55
	C-sel. to C <sub>3</sub> H <sub>6</sub> (20h) (%)	95	94
	Yield of C <sub>3</sub> H <sub>6</sub> (20h) (%)	28.5	51.7
	Conv. of O <sub>2</sub> (5h) (%)	100	100
	O-sel. to (H <sub>2</sub> O) (5h) (%)	88	80
	Conv. of O <sub>2</sub> (20h) (%)	100	100
	O-sel. to H <sub>2</sub> O (20h) (%)	95	87

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(1) A catalyst according to U.S. Pat. 4,788,371, containing 0.65 wt.% Pt, 1.15 wt.% Sn and 2.18 wt.% Cs on (θ)-Al<sub>2</sub>O<sub>3</sub>.

(2) A new catalyst, containing 0.3 wt.% Pt and 1.2 wt.% Sn on Mg(Al)O.

The results in Table 2 show that the new catalyst I and the known catalyst II, which are both described in Example 11, are both capable of achieving a selective oxidation of the hydrogen in the gas mixture.

5           The conversion of propane  $C_3H_8$ , and thus the yield of propene  $C_3H_6$ , is substantially higher for the new catalyst than for the known catalyst, viz. 57% versus 45% after 5 hours, and 55% versus 30% after 20 hours of operation, respectively. The higher propene yield was achieved in spite of the fact that  
10 the gas space velocity per gram of catalyst and per hour (GHSV) was higher for the new catalyst ( $2100 \text{ N ml g}^{-1} \text{ h}^{-1}$  versus  $1400 \text{ N ml g}^{-1} \text{ h}^{-1}$  for the known catalyst), and in spite of the fact that the content of active noble metal (platinum) was substantially lower in the new catalyst (0.3 wt.% versus 0.65  
15 wt.% in the known catalyst). The higher (GHSV) used with the new catalyst was due to the fact that this catalyst had a lower bulk weight than the known catalyst. As a consequence of the lower bulk weight of the new catalyst, the advantage resulting from its low content of platinum was even more  
20 important than suggested by the percentual content alone. A low content of platinum in a commercial catalyst is important from an economical point of view.

          The selectivity for oxidation of hydrogen to water is somewhat higher for the known catalyst than for the new  
25 catalyst, viz. 88% versus 80% after 5 hours, and 95% versus 87% after 20 hours of operation, respectively. This may be explained at least partly by the fact that the lower propane conversion achieved by the known catalyst resulted in the formation of lesser amounts of the desired dehydrogenated  
30 product, propene. Thus, with the known catalyst the oxidation of hydrogen to water was less burdened by competing oxidation of propene to carbon oxides.

Patent claims

1. A catalyst,  
5 c h a r a c t e r i z e d in that it comprises a combination of a carrier, constituted essentially by a mixed oxide of magnesium and aluminum  $Mg(Al)O$ , a Group VIII noble metal, a Group IVA metal, and optionally a Group IA alkali metal.
- 10 2. A catalyst according to claim 1, c h a r a c t e r i z e d in that it has been subjected to a pretreatment (ROR pretreatment) comprising a reduction, a subsequent oxidation and finally a second reduction.
- 15 3. A catalyst according to claim 1, c h a r a c t e r i z e d in that it has been subjected to a ROR pretreatment comprising a reduction in hydrogen, followed by an oxidation in air optionally mixed with nitrogen, and finally a second reduction in hydrogen.
- 20 4. A catalyst according to any of claims 1 to 3, c h a r a c t e r i z e d in that the molar ratio of magnesium to aluminum in the  $Mg(Al)O$  carrier is ranging from 1:1 to 10:1, preferably from 2:1 to 5:1.
- 25 5. A catalyst according to any of claims 1 to 4, c h a r a c t e r i z e d in that the surface area of the  $Mg(Al)O$  carrier is from 10 to 400  $m^2/g$ , preferably from 100 to 300  $m^2/g$ , more preferred from 140 to 210  $m^2/g$ .
- 30 6. A catalyst according to any of claims 1 to 5, c h a r a c t e r i z e d in that it contains:  
0.05 - 5.0 wt.% Group VIII noble metal,  
0.05 - 7.0 wt.% Group IVA metal,  
35 0 - 5.0 wt.% Group IA metal,  
calculated on the total weight of the catalyst.
7. A catalyst according to claim 6, c h a r a c t e r i z e d in that it contains 0.1-1.0 wt.%

of Group IA metal.

8. A catalyst according to claim 6,  
c h a r a c t e r i z e d in that it contains:

- 5 0.1 - 1.0 wt.% Group VIII noble metal,  
0.1 - 3.0 wt.% Group IVA metal,  
0 - 0.7 wt.% Group IA metal,  
calculated on the total weight of the catalyst.

10 9. A catalyst according to claim 8,  
c h a r a c t e r i z e d in that it contains 0.3-0.7 wt.%  
of Group IA metal.

10. A catalyst according to claim 8,  
15 c h a r a c t e r i z e d in that it contains:  
0.2 - 0.4 wt.% Group VIII noble metal,  
0.3 - 1.5 wt.% Group IVA metal,  
0 - 0.6 wt.% Group IA metal,  
calculated on the total weight of the catalyst.

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11. A catalyst according to claim 10,  
c h a r a c t e r i z e d in that it contains 0.4-0.6 wt.%  
of Group IA metal.

25 12. A catalyst according to any of claims 1 to 11,  
c h a r a c t e r i z e d in that the Group IVA metal is tin  
or germanium, preferably tin.

13. A catalyst according to any of claims 1 to 12,  
30 c h a r a c t e r i z e d in that the Group VIII noble metal  
is platinum or palladium, preferably platinum.

14. A catalyst according to any of claims 1 to 13,  
c h a r a c t e r i z e d in that the Group IA alkali metal  
35 is cesium or potassium, preferably cesium.

15. A catalyst according to any of claims 1 to 14,  
c h a r a c t e r i z e d in that the Group VIII noble metal  
has been incorporated therein by a deposition process.

16. A catalyst according to any of claims 1 to 15, characterized in that the Group IVA metal and any employed Group IA metal have been incorporated therein by a deposition process.

17. A catalyst according to any of claims 2 to 16, characterized in that the ROR pretreatment has been carried out at temperatures of 500° to 700°C.

18. A process for preparing a catalyst according to claim 2, characterized by the steps of incorporating a Group VIII noble metal, a Group IVA metal and optionally a Group IA alkali metal into a carrier consisting essentially of a mixed oxide of magnesium and aluminum  $Mg(Al)O$ , and subjecting the material thus obtained to a pretreatment (ROR pretreatment) comprising a reduction, preferably in hydrogen, a subsequent oxidation, preferably in air optionally mixed with nitrogen, and finally a second reduction, preferably in hydrogen.

19. A process for dehydrogenating dehydrogenatable  $C_{2-30}$  hydrocarbons, preferably  $C_{2-5}$  paraffins, comprising contacting the hydrocarbons under suitable dehydrogenation conditions in one or more reaction zones with a solid catalyst comprising a Group VIII noble metal, a Group IVA metal and an inorganic oxide carrier, characterized by there being used a catalyst according to any of claims 1 to 17.

20. A process according to claim 19, characterized in that the dehydrogenation is carried out at a temperature ranging from 500° to 700°C, a pressure ranging from 0.5 to 1.5 bars absolute, and using a space velocity (GHSV) of 10 to 10,000  $N\ ml\ g^{-1}\ h^{-1}$ .

21. A process for dehydrogenating dehydrogenatable  $C_{2-30}$  hydrocarbons, preferably  $C_{2-5}$  paraffins, combined with admixture of an oxygen-containing gas, preferably oxygen,

comprising contacting the hydrocarbons under suitable dehydrogenation conditions in one or more reaction zones with a solid catalyst comprising a Group VIII noble metal, a Group IVA metal and an inorganic oxide carrier,

5 c h a r a c t e r i z e d by there being used a catalyst according to any of claims 1 to 17.

22. A process according to claim 21,

c h a r a c t e r i z e d in that the dehydrogenation is  
10 carried out at a temperature ranging from 400° to 700°C, a pressure ranging from 0.5 to 3 bars absolute, and using a space velocity (GHSV) of from 10 to 10,000 N ml g<sup>-1</sup> h<sup>-1</sup>.

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## INTERNATIONAL SEARCH REPORT

International application No.

PCT/NO 94/00102

## A. CLASSIFICATION OF SUBJECT MATTER

IPC 5: B01J 23/62, B01J 21/10, B01J 37/18, C07C 5/333, C07C 5/48  
According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 5: B01J, C07C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

SE,DK,FI,NO classes as above

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EDOC

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US, A, 3670044 (LEWIS E. DREHMAN ET AL), 13 June 1972 (13.06.72), column 1, line 34 - line 37; column 1, line 61 - line 69; column 3, line 30 - line 35, claims 1,2,5,6,9, abstract	1,5,6,8,10, 12,13,15,16, 19-22
Y	column 3, line 27 - line 29, claim 5  --	1-3,7,9,11, 14,17,18,21, 22
X	US, A, 4169815 (LEWIS E. DREHMAN), 2 October 1979 (02.10.79), column 2, line 30 - line 65; column 3, line 15 - line 23; column 5, line 22 - line 62, abstract	1,5-16,19,20
Y	column 5, line 61 - line 62  --	2,3,17,18

☒ Further documents are listed in the continuation of Box C.☒ See patent family annex.

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"&amp;" document member of the same patent family

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## C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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Y	EP, A1, 0323115 (UOP), 5 July 1989 (05.07.89), page 7, line 17 - line 25, claims 1,6,7, abstract  --	1-3,7,9,11, 14,17,18,21, 22
A	US, A, 3842139 (WILLIAM L. KEHL ET AL), 15 October 1974 (15.10.74), column 6, line 61 - line 64, claim 10, abstract  -- -----	1,5,19

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Information on patent family members

27/08/94

International application No.  
PCT/NO 94/00102

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